

Date: Monday, 05/03/2007 12:34:27 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 30993		
Estimate Number	: 10256		
P.O. Number	: <i>NA</i>	Part Number	: D22303
This Issue	: 05/03/2007 S.O. No. : <i>NIA</i>	Drawing Number	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 01/03/2007 Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 30545	Material	: <i>NA</i>
Written By	: <i>[Signature]</i>	Due Date	: 03/12/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	1,000 Um: Each
Comment	: Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total: 71.7150 f(s)
 Lug Extrusion
 D2423
 Batch: *B 30062*

2.0	BAND SAW	BAND SAW
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Comment: Band Saw
 Cut D2423 extrusion to 0.82"
 Batch: *N/A*

3.0	PG	PURCHASING
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Comment: PURCHASING
 Issue P/O *BKKT00001*
 Possible Supplier : Metec
 Machine per Drwg D2230 Rev. F

30 - June 12, 2007
124 - June 15, 2007
60 - June 18, 2007
296 - June 26, 2007
C 07/10 3108
296

1000
[Signature]

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect for transit damage

07/06/26 (296)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30993

Part Number: D22303

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/03 counted
X296

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

M/A

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-L 07/07/16

296X

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/16 X296

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M101575

BR 07-07-16

296

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

En 7/7/17 296

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

476 En 7/7/17 296

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.17 Hy

Job Completion

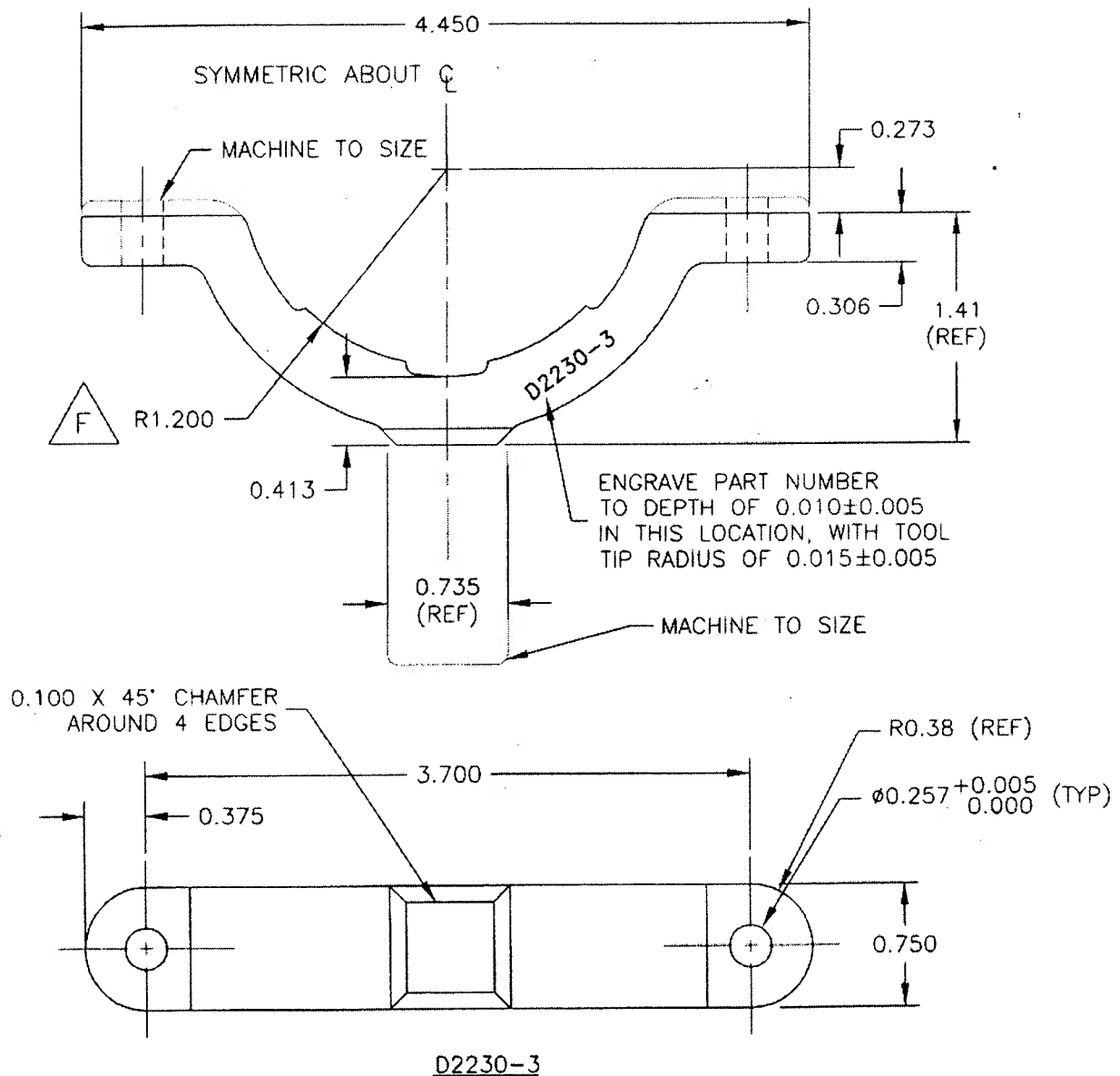


U 07.07.17



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
19.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3.432
257
3.689

60
620
130
240
296

**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

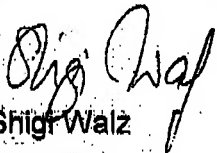
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
296	D2230-3	Lug B30993	BLKT00001
100	D3394-3	Lug B30993	BLKT00001

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shig Walz

Vankleek Hill, June 26, 2007